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D2570
Job Sheet 189316



Part No: D2570

Job Qty: 150 pcs *140 Pcs*

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/14/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG REV B IPP E 02.08.29 Re-format; Removed finishing; Material change KJ IPP F 07.07.06 rev B dwg EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Hardinge - 1	150 pcs	2/14/19	2/14/19	0.50	6.00	Hardinge - 1	<i>JSD 1/31/19</i>
110	QC 2	150 pcs	2/14/19	2/14/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	<i>JSD 1/31/19</i>
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

120 QC 8

150 pcs

2/14/19

0.00 0.00

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 38

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

2/19/01/31

130 Packaging 3-1 - Stock - B4B 150 pcs

2/14/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Stacy JAN 31 2019

140 QC 21 - SA

150 pcs

2/14/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

DAS
21
9-05 JAN 31 2019

Part Op 100 - (Hardinge)Machine as per folio FA258
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

Entered: _____ Date: _____



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Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

- 120 - (QC8- Inspect parts - second check)
 130 - LOCATION : ST008
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	9.9000 ft (.066 ea)	100-Hardinge - 1	S119664

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.750	10	20	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.800inches ± 0.010	0.810 0.790	8	
2	Bushing	0.060inches ± 0.005	0.065 0.055	0.058	
3	Bushing	0.010inches + 0.010 - 0.000	0.020 0.010		
4	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423	0.424	
5	Bushing	0.257inches + 0.006 - 0.001	0.263 0.256	0.2595	
6	Bushing	0.750inches ± 0.010	0.760 0.740	0.745	
7	Bushing	0.030inches ± 0.010	0.040 0.020	0.033	
8	Bushing	20.000Degrees ± 0.000	20.000 20.000	20°	

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Entered: _____ Date: _____



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Date : _____	Sequence #: _____	QTY Affected : _____			MRB (QSI042)	
Description Work Order Deviation		Disposition				
		Completed By				
		Lead hand / Supervisor				
		QC / QA Coordinator				
		FAULT CATEGORY				
		☐ Power Loss/Surge ☐ Positioned Wrong ☐ Folio/Program ☐ Outside Tolerance ☐ Grain Direction ☐ Drawing ☐ Weld ☐ Finish ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Out of Sequence ☐ Misread ☐ Off-set/Set-up				

Part: D2570
Job No: 189316
Serial No/Batch: S149607
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 01/31/19



Container No: S149607



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Direct Instructions